

Amendments to the Claims:

This listing of claims will replace all prior versions, and listings, of claims in the application:

Please cancel claims 9 and 20 without prejudice or disclaimer.

Please rewrite claims 10-15, 18, 21-23 and 28 to read as follows:

Listing of Claims:

1. (cancelled)
2. (previously presented) The lithium secondary battery according to claim 6, wherein a center axis of said winding core overlaps a center axis of said battery case.
3. (previously presented) The lithium secondary battery according to claim 6, wherein said external terminals are made to comprise a center hollow portion so that this center hollow portion functions as a pressure release path of said pressure release hole.
4. (cancelled)
5. (previously presented) The lithium secondary battery according to claim 6, wherein said winding core has thickness of not less than 0.8 mm.
6. (currently amended) A lithium secondary battery comprising:
 - an internal electrode body formed by winding a positive electrode and a negative electrode on an outer peripheral wall of a hollow cylindrical winding core;
 - a cylindrical battery case containing the internal electrode body inside with both ends thereof being open;
 - ~~nonaqueous~~-nonaqueous electrolyte solution contained in said case and contacting said positive electrode and said negative electrode; and
 - electrode caps having battery caps, internal terminals, and external terminals which seal said internal electrode body at both open ends of the battery case,
 - wherein at least one of the electrode caps has a pressure release hole in a position corresponding with the center axis of the winding core,

wherein the capacity (C) of said internal electrode body is not less than 2 Ah, and said pressure release hole's sectional area (S_1) as well as said winding core's center hollow portion's sectional area (S_2) are larger than 0.3 (cm²),

and wherein the values given by dividing said pressure release hole's sectional area (S_1) and said winding core's center hollow portion's sectional area (S_2) by said internal electrode body's battery capacity (C) respectively (S_1/C and S_2/C) are both larger than 0.02 (cm²/Ah).

7. (previously presented) The lithium secondary battery according to claim 6, wherein the size of said winding core's center hollow portion's sectional area (S_2) is not less than said pressure release hole's sectional area (S_1).

8. (previously presented) The lithium secondary battery according to claim 6, wherein said winding core is made of aluminum or an aluminum alloy.

9. (cancelled)

10. (currently amended) The lithium secondary battery according to claim 914, wherein said metal foil is formed so as to have a surface pressure of not less than 980 kPa.

11. (currently amended) The lithium secondary battery according to claim 914, wherein said spacer is formed with a metal material having a Young's modulus not less than 170 Gpa.

12. (currently amended) The lithium secondary battery according to claim 914, wherein said spacer is a ring member or a ring member having stopper structure in order that stress of less than a constant amount will be applied to said elastic body.

13. (currently amended) The lithium secondary battery according to claim 914, wherein said metal foil is made of Al, Cu or Ni, said metal foil being coated by fluoride resin.

14. (currently amended) ~~The~~ A lithium secondary battery according to claim ~~9~~
comprising:

an internal electrode formed by winding a positive electrode and a negative electrode
on an outer peripheral wall of a hollow cylindrical winding core;

a cylindrical battery case containing the internal electrode body inside with both ends
thereof being open;

nonaqueous electrolyte solution contained in said case and contacting said positive
electrode and said negative electrode; and

electrode caps having battery caps, internal terminals, and external terminals, said
battery caps sealing said internal electrode body at both open ends of the battery case, at least
one of said battery caps having a pressure release hole in a position corresponding with a
center axis of said winding core,

wherein a pressure release valve is disposed on an internal peripheral wall of said
pressure release hole or at the end of said pressure release hole, said pressure release valve
comprising an elastic body, a metal foil and a spacer, said elastic body and said metal foil
being brought into pressure contact with said spacer to seal said battery case, and

wherein stress applied to said elastic body is not less than 980 kPa and not more than
a force at which said elastic body maintains elasticity of not less than 95%.

15. (currently amended) The lithium secondary battery according to claim ~~9~~14, wherein
said elastic body is packing processed in advance to a predetermined size.

16. (original) The lithium secondary battery according to claim 15, wherein said packing
is made of ethylene propylene rubber, polyethylene, polypropylene or fluoride resin.

17. (cancelled)

18. (currently amended) The lithium secondary battery according to claim ~~16~~14, wherein
said pressure release hole is used as the electrolyte solution inlet.

19. (currently amended) A lithium secondary battery comprising:
an internal electrode formed by winding a positive electrode and a negative electrode on an outer peripheral wall of a hollow cylindrical winding core;
a cylindrical battery case containing the internal electrode body inside with both ends thereof being open;
~~nonqueous~~ nonaqueous electrolyte solution contained in said case and contacting said positive electrode and said negative electrode; and
electrode caps which seal said internal electrode body at both open ends of the battery case,
said electrode caps being substantially rotationally symmetrical around the center axis of said battery case,
wherein at least one of the electrode caps has a pressure release hole, and said pressure release hole has a sectional area (S_1) which is larger than 0.3 cm^2 , and said winding core has a center hollow portion having a sectional area (S_2) which is larger than 0.3 cm^2 , and wherein the capacity (C) of said internal electrode body is not less than 2 Ah.

20. (cancelled)

21. (currently amended) The lithium secondary battery according to claim ~~9~~14, which has a battery capacity of not less than 2 Ah.

22. (currently amended) The lithium secondary battery according to claim ~~1~~6, which is a battery to be mounted on vehicles.

23. (currently amended) The lithium secondary battery according to claim ~~9~~14, which is a battery to be mounted on vehicles.

24. (original) The lithium secondary battery according to claim 22, which is for an engine starter.

25. (original) The lithium secondary battery according to claim 23, which is for an engine starter.

26. (original) The lithium secondary battery according to claim 22, which is used in an electric vehicle or a hybrid electric vehicle.

27. (original) The lithium secondary battery according to claim 23, which is used in an electric vehicle or a hybrid electric vehicle.

28. (currently amended) A method of manufacturing a lithium secondary battery, which comprises:

preparing plate-like members functioning as caps after production, elastic bodies, metal foils and spacers which are processed in advance to a predetermined size;

disposing each said elastic body and each said metal foil in predetermined positions;

combining each said elastic body and each said metal foil with a said spacer to form a pressure release hole unit;

fitting each said pressure release hole unit into a said plate-like member to produce electrode caps;

positioning an internal electrode body in a battery case; and

sealing the battery case with said electrode caps,

wherein stress applied to said elastic body is not less than 980 kPa and not more than a force at which said elastic body maintains elasticity of not less than 95%.